

Date: Tuesday, 28/04/2009 2:20:31 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212 BASKET BASE ASS'Y RH  
 Job Number : 47572B  
 Estimate Number : 11543  
 P.O. Number : Part Number : D3053042  
 This Issue : 28/04/2009 S.O. No. : Drawing Number : D3053 REV B  
 Prsht Rev. : NC Project Number :  
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : B  
 Previous Run : 41327B Material : SHIP  
 Due Date : 05/05/2009 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JLD 09.04.28  
 Comment : Est. C 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K  
 J/RF  
 Est Rev:D 08-08-29 revB as per dwg DD verified by:EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W



Comment: Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s)  
 304 SQ Tube.75x.75x.065W

1-Cut Rib from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

Batch: H111331

2-Drill holes in D3053-3 as per dwg D3053

PD 09.05.04

2.0	D31661	Basket Hoop
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 Basket Hoop

Qty. 5 D3166-1

Batch: B46867 → 2 B47012 → 3

PD 09.05.04

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut 5 D2235-3 FROM D3166-1 using DT8365

2-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995

PD 09.05.04

4.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Pick:

Qty Part Number

Description

Batch

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Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 47572B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2327-3

Bushing

B44365

SM 09/05/06

5.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Basket Hinge

Pick:

Qty Part Number Description Batch

2 D2232-3 Hinge plate

B46626 → 2x

SM 09/05/11

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Mounting Bracket

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B46086 → 2x

SM 09/05/11

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)  
Expanded Metal Flat Stai

Pick:

Qty Part Number

Description

Batch

48sq.ft M304EX0.75-16F

Expanded Metal

M111444

SM 09/05/11

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove all markings from material

2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

SM 09/05/15 (1x)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PLC 09-05-19

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 47572B

Part Number: D3053042

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

509/05/19 @

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Take Traveller D205-541-043 to KP

12.0 POWDER COATING POWDER COATING



Comment: POWDER COATING x pressure wash 09-05-19 x0 M

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

1st COAT

2ND COAT

START TIME: 14:00

START TIME: 14:45

OVEN TEMPERATURE: 400

oven temp: 400

FINISH TIME: 14:30

Finish time: 15:15

09/05/19

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SL 09-05-20 @

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 47572

9/5/20

(K)

SP

15.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/20

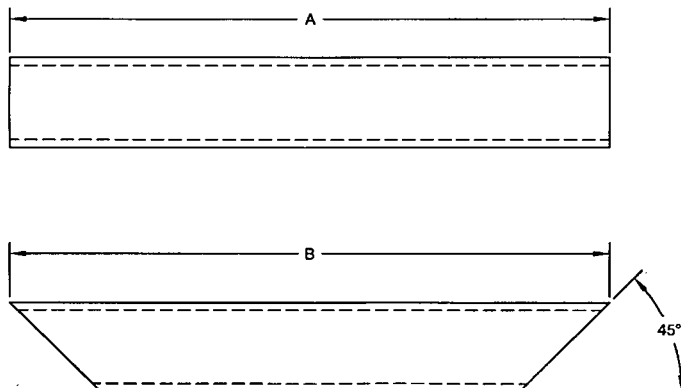
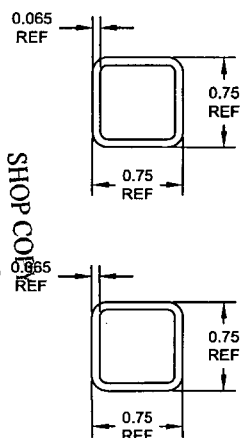
Job Completion



MF 09-05-20

# **PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



NO. 175  
WORK ORDER  
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SUBJECT TO AMENDMENT



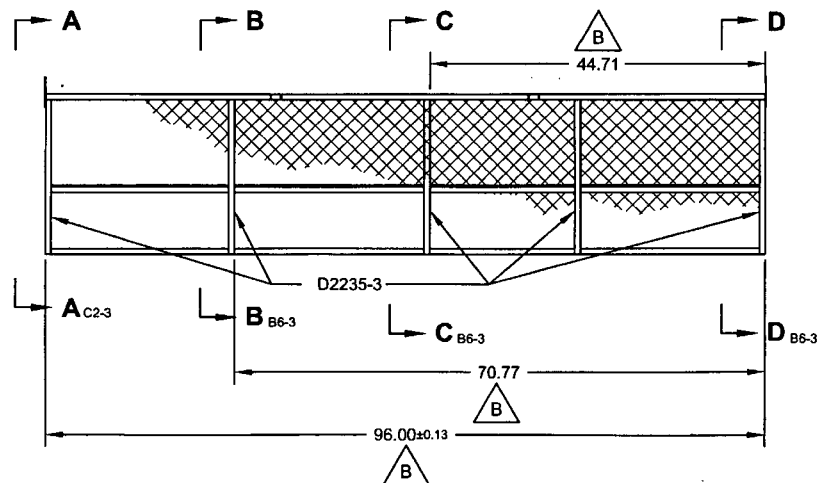
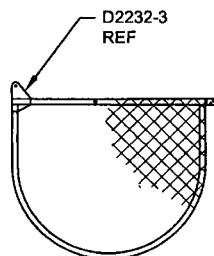
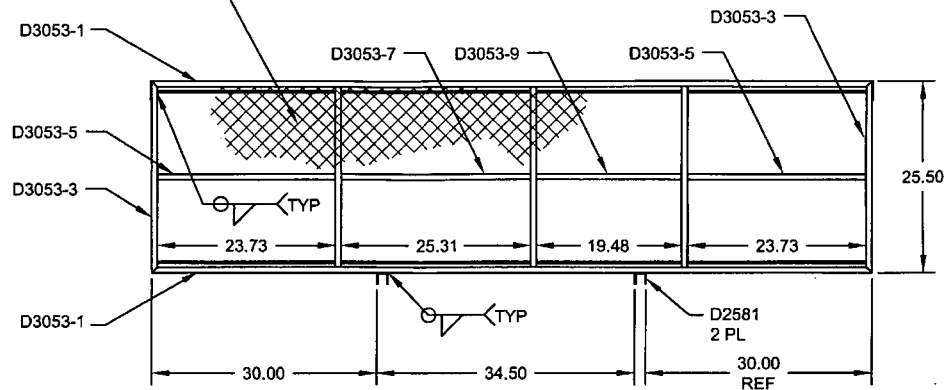
## **NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

**RELEASED**  
08.07.02

B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	08.07.02	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SKIN INSIDE SURFACE OF  
BASKET WITH MESH. TACK  
WELD EACH END OF STRAND  
TO FRAME

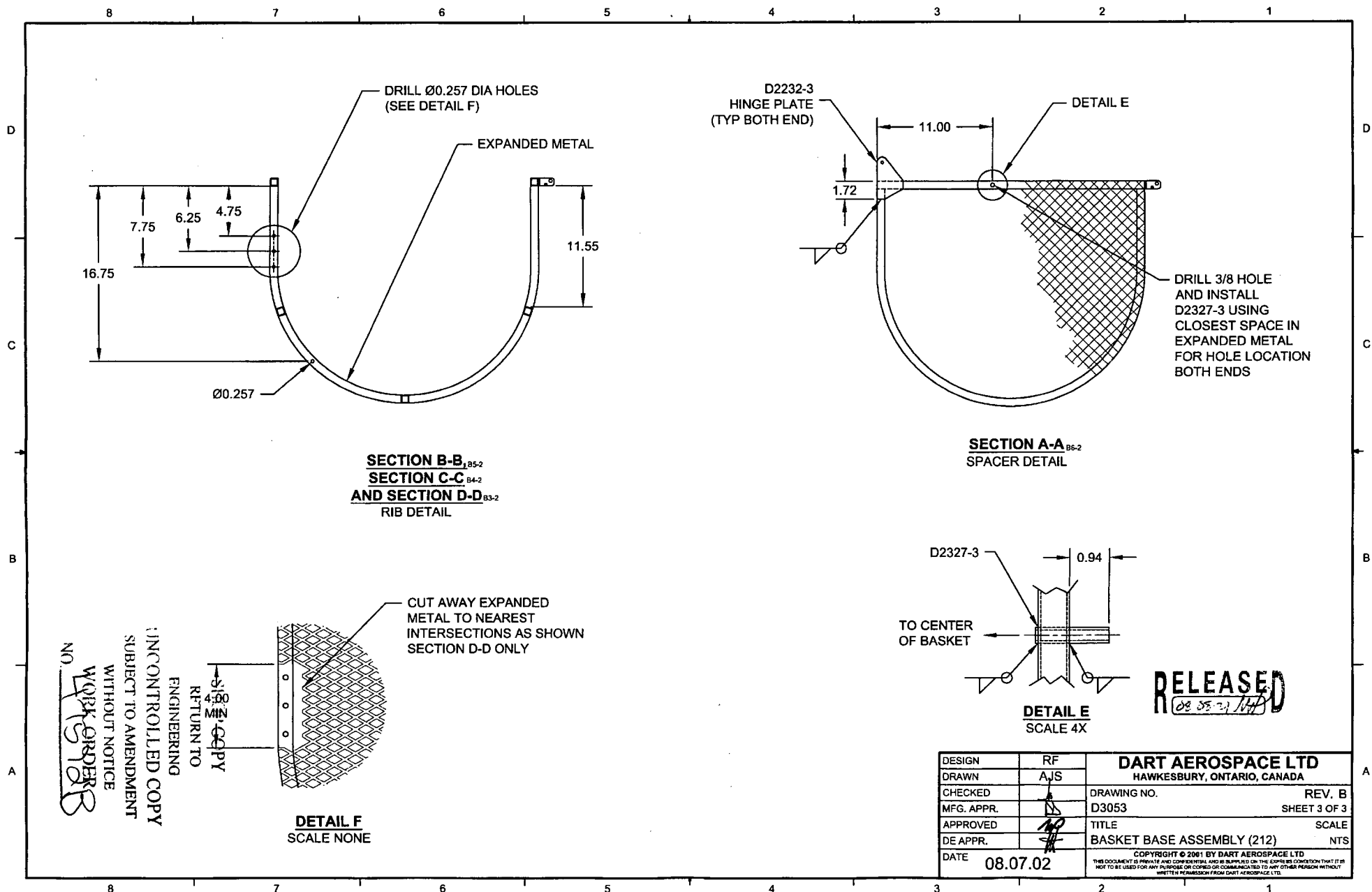


**D3053-042 BASKET BASE ASSEMBLY SHOWN  
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)**

**RELEASED**  
08.08.12

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WORK ORDER NO. 47928

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	08.07.02	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

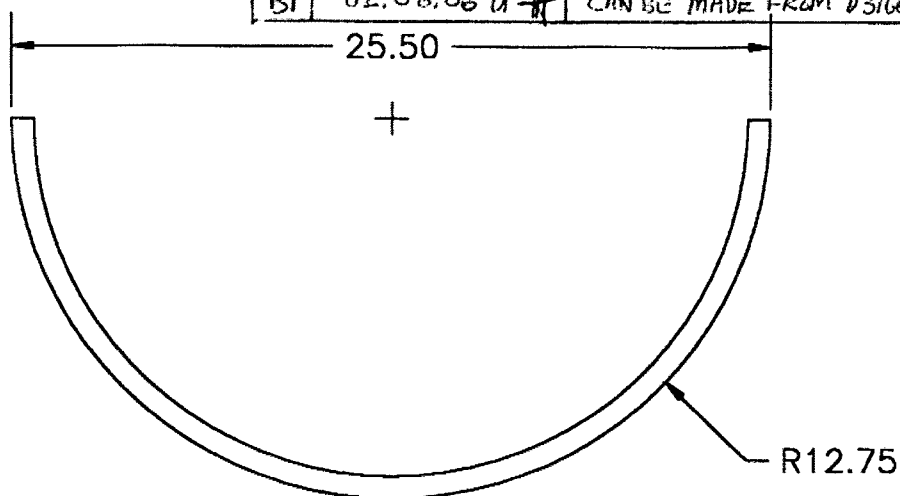




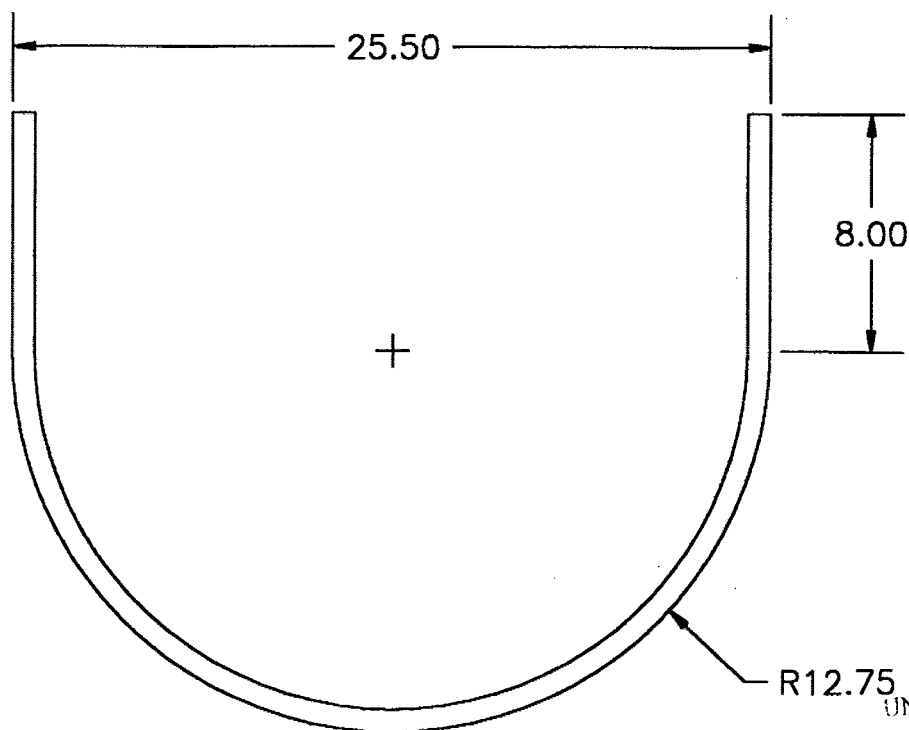
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2235	SHEET 1 OF 1
DATE	TITLE	SCALE	
94:12:16	BASKET RIBS		

BI 02.08.06 11-11 CAN BE MADE FROM D3166-1


RELEASED  
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1   
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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